



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4971-1
Job Sheet 163052



Part No: D4971-1

Job Qty: 6 ea

Part Name: T/R Bellcrank Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/11/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A 13.11.19 NEW ISSUE DD VERF:JLM IPP REV:B 14.04.01 PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/1/17	12/1/17	0.00	0.00	Start Up Waterjet		SC 8/05/08
100	Waterjet	6 pcs	12/1/17	12/1/17	0.00	0.65	Waterjet1		SC 8/05/08
110	QC	6 pcs	12/1/17	12/1/17	0.00	0.00	QC2		DAS
120	QC	6 pcs	12/1/17	12/1/17	0.00	0.00	QC8		38
130	Brake NC	6 pcs	12/1/17	12/1/17	0.04	0.60	Brake NC 1		DAS SP
140	QC	6 pcs	12/1/17	12/1/17	0.00	0.00	QC5		38
150	HandFinish	6 pcs	12/1/17	12/1/17	0.00	0.36	HandFinish1		REB 18-05-12
160	QC	6 pcs	12/1/17	12/1/17	0.00	0.00	QC7		BH 18-5-9
170	Powdercoat	6 pcs	12/1/17	12/1/17	0.00	0.23	Powdercoat4		DAS
180	QC	6 pcs	12/1/17	12/1/17	0.00	0.00	QC3	DAS	1 MAY 10 2008
190	Packaging	6 pcs	12/1/17	12/1/17	0.00	0.00	Packaging3	21	9-89
200	QC21-SA	6 Ea	12/1/17	12/1/17	0.00	0.00	QC21	3-86	MAY 10 2018

MISLARD MIBS200 START: 3:55 00:13:30 FINISH: 1:25
5018292

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	3.5400 sf (.59 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	4	63	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Suspected U		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		DART AEROSPACE Container No: S068205 Part: D4971 - 1 Sub No: 163052 Serial No/ Batch: S063205 Revision: _____ Inspector: _____ Date: 05/03/18 1270 Jordan Street Wainwright, ON K6A 1K7 TEL: 1 813 632-8200 Email: sales@dartaero.com www.dartaerospace.com			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Force ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Dimensioned Wrong ☐ Inside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	T/R Bell Crank Cover	0.098Inches + 0.004 - 0.001	0.102 0.097	0,699	
2	T/R Bell Crank Cover	0.201Inches + 0.005 - 0.001	0.206 0.200	0,203	
3	T/R Bell Crank Cover	0.330Inches ± 0.030	0.360 0.300	0,333	
4	T/R Bell Crank Cover	2.500Inches ± 0.010	2.510 2.490	2,502	
5	T/R Bell Crank Cover	0.520Inches ± 0.030	0.550 0.490	0,526	
6	T/R Bell Crank Cover	0.700Inches ± 0.030	0.730 0.670	0,709	
7	T/R Bell Crank Cover	0.500Inches ± 0.030	0.530 0.470	0,507	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					